

Work Order ID 62948



Page 1

Thursday, October 14, 2010 12:34:28 PM

Item ID: D3675-1

Accept



Setup Start



Revision ID:

Item Name: SLIDING DOOR BRACKET

Stop



Start Date: 10/14/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 10/10/14

Tooling:

Date:

Run Start



QC:



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3675	Rev B

100	0.00	10/10/14
-----	------	----------

FLOW WATER JET	0.00	10/10/14
----------------	------	----------

Waterjet	Memo	1-Cut as per Dwg D3675	<input type="checkbox"/> Dwg Rev: B	<input type="checkbox"/> Prog Rev: B	<input type="checkbox"/> 2-	Deburr if necessary	20
----------	------	------------------------	-------------------------------------	--------------------------------------	-----------------------------	---------------------	----

110	QC2- Inspect parts off machine FAI/FAIB	0.00	10/10/14
-----	---	------	----------

QC	Memo	0.00	10/10/14
----	------	------	----------

Quality Control			10/10/14
-----------------	--	--	----------

120	QC8- Inspect parts - second check	0.00	10/10/14
-----	-----------------------------------	------	----------

QC	Memo	0.00	10/10/14
----	------	------	----------

Quality Control			10/10/14
-----------------	--	--	----------

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

Brake NC

Form as per Dwg D3675

SB 10/10/22
EF 10/10/25

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

S10/10/25

Counted
120

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

M112588

Memo

Powder Coating

START TIME:

2:00

OVEN TEMPERATURE:

FINISH TIME:

2:30

20 BK 10-10-07.

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Work Order ID 62948

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Thursday, October 14, 2010 12:34:28 PM

Item ID: D3675-1

Accept



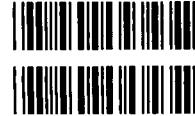
Setup



Revision ID:

Item Name: SLIDING DOOR BRACKET

Stop



Start Date: 10/14/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan

Code

Accept

Qty

Reject

Qty

Reject

Number

Insp.

Stamp

7/11 10/10/27

20 0

170



Packaging

Packaging

Identify as per dwg & Stock Location 236A

0.00

10/10/28 S/20

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/28 J

MF
10-10-28

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NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, October 14, 2010 12:34:31 PM

Work Order ID: 62948



Parent Item: D3675-1



Parent Item Name: SLIDING DOOR BRACKET

Start Date: 10/14/2010

Required Date: 10/22/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A new issue 08-04-21 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	108.6987	0.121	2.547368			

304/316 .040 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	85.9522	
114574	10.6522	
115762	75.3	115762
MAT20	22.7465	
112885	2.7475	
113062	0.699	
115440	19.3	

10-10-19

(20)

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	62948
Description: Sliding Door Bracket	Part Number:	D3675-1
Inspection Dwg: D3675 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>RB</u>	Audited by: <u></u>	Preliminary Approval: N/A
Date: <u>10-10-19</u>	Date: <u>10/10/19</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.09.12	New Issue	KJ/DD	
B	10.09.01	Dwg Rev updated	KJ	

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NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

C

B

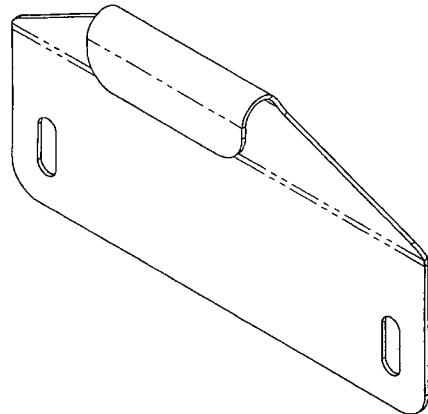
A

D

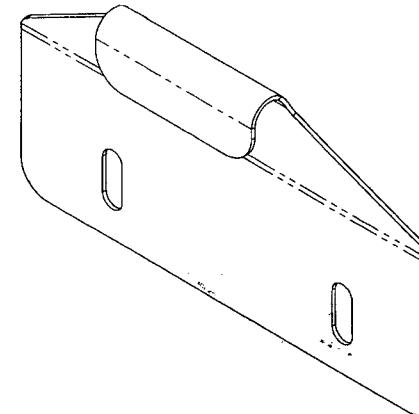
C

B

A



D3675-1 SLIDING DOOR BRACKET



**D3675-3 SLIDING DOOR BRACKET
(HINGE PANEL MOD)**

SHO 2007
 1
 UNCO
 SUB
 V
 WO
 NO. 62948
 010-1014

RELEASED
08.11.10 M

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED)
REF. DART SPEC M304S
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

B	ADD-3 FOR HINGE PANEL MOD.	AJS	08.11.03
A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3675	SHEET 1 OF 3
APPROVED		TITLE SLIDING DOOR BRACKET SCALE (COMPOSITE DOOR) NTS	
DE APPR.		DATE 08.11.03	

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8

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2

1

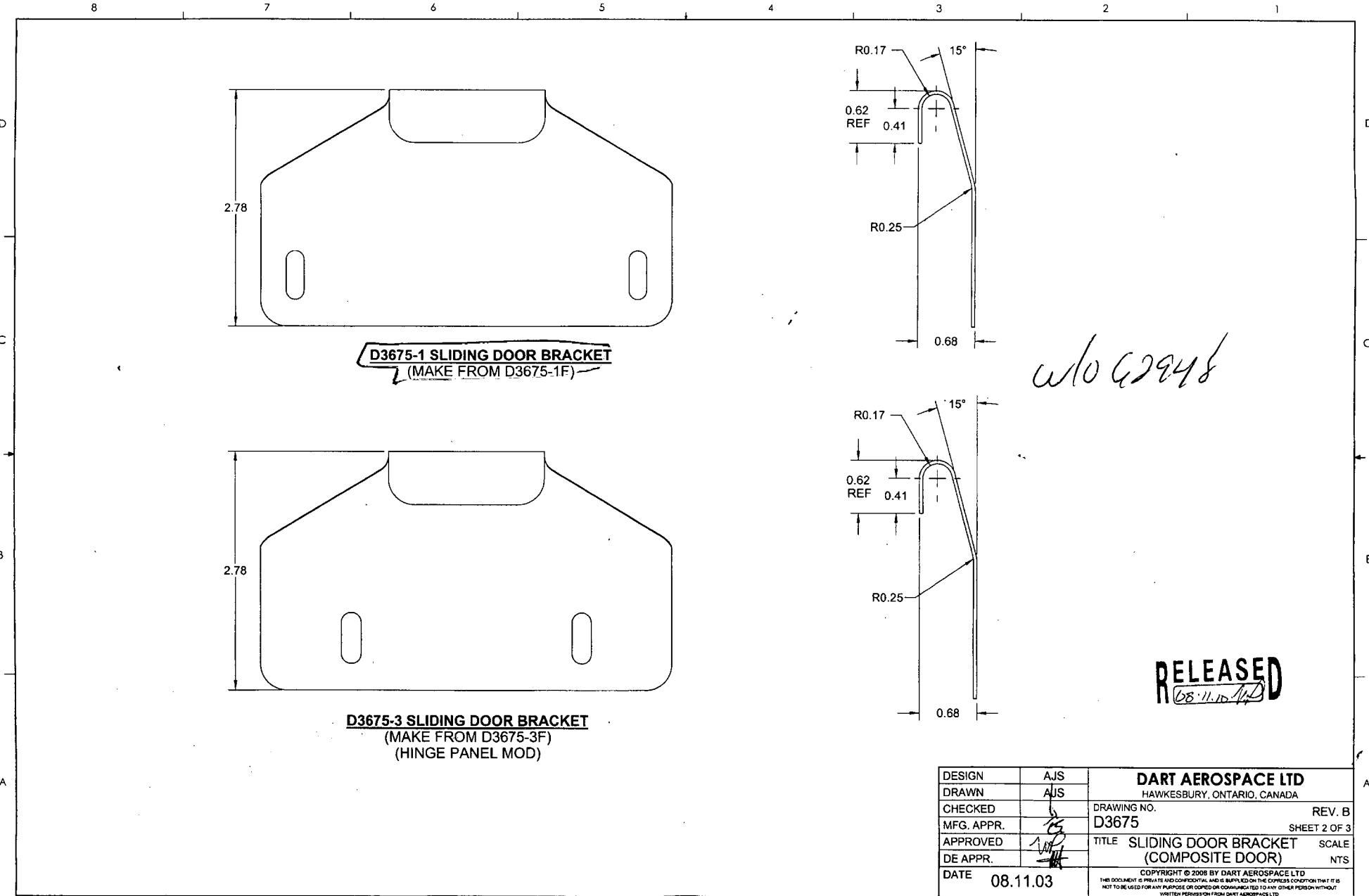
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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3675	
MFG. APPR.		REV. B	
APPROVED		SHEET 2 OF 3	
DE APPR.		TITLE SLIDING DOOR BRACKET	
DATE	08.11.03	SCALE (COMPOSITE DOOR) NTS	

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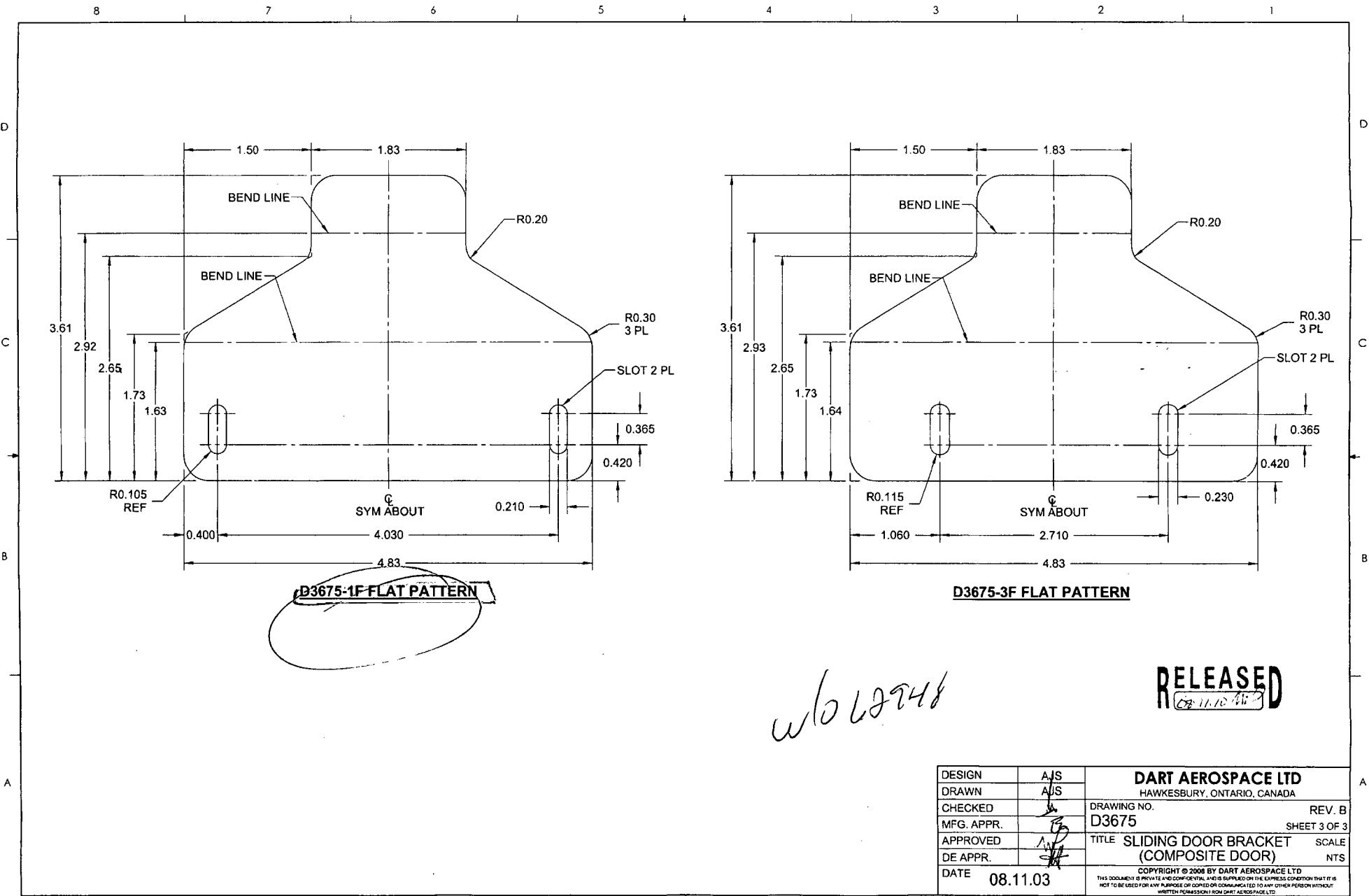
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